

Work Order ID 82356

82356

March-29-12 2:33:26 PM

Page 1

Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Airframe Hinge
Start Date: 29/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 12/04/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/29 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4072	B

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.00	PO/B.a	12/05/05		12	Ø		
Jéaspa Bandsaw	CUT 1.250" LONG								

105		0.00							
105									
HAAS I	Memo	0.00	PO/B.a	12/05/05		12	Ø		
HAAS CNC vertical machine #1	Mill as per Dwg an Folio FA938 Dwg Rev: <u>B</u> Folio Rev: <u>AA</u>								

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		PO/B.A	12/05/05	12	Ø		
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		RE 12-5-5		12	Ø		
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				12	Ø	Ø	14/05/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating M121134	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo	0.00 0.00				12x	✓		M- 12/25/07
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	✓		BL 12-58
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>87120</u> Memo	0.00 0.00				12x			SP 12-5-8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12038

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-29-12 2:33:30 PM

Page 1

Work Order ID: 82356

82356

Parent Item: D4072-1

D4072-1

Parent Item Name: Airframe Hinge

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD
REV:B DRAWING REV. CHANGE AS PER ECN 11-598
VERIFIED BY:

IPP
11-07-05 JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.50 0		Purchased	No			100	f	15.4200	0.104	1.313684			

M6061T6B1 000X02 500

6061-T6 Bar 1.00 x 2.50

**

PO

12/05/05

Location

Loc Qty

Loc Code

MAT003

15.42

114993

15.42

1

1.35

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82356
Description: Airframe Hinge		Part Number:	D4072-1
Inspection Dwg: D4072 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

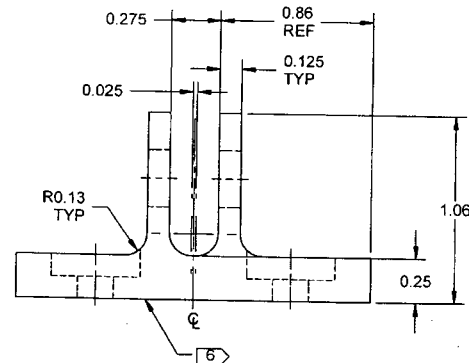
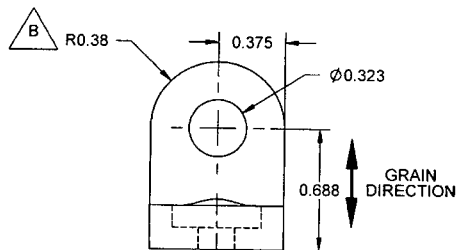
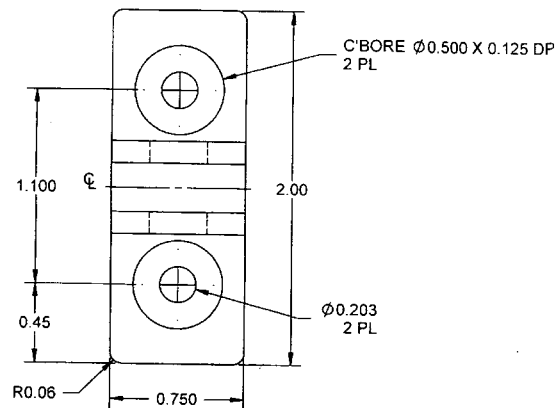
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	0.503 x 0.125	✓		VERN	PHD-01
2.00	+/-0.030	1.999	✓		"	"
Ø0.203	+0.005/-0.001	0.205	✓		"	"
0.750	+/-0.010	0.747	✓		"	"
R0.06	+/-0.030	0.060	✓		Rad gauge	
0.45	+/-0.030	0.450	✓		VERN	PHD-01
1.100	+/-0.010	1.104	✓		"	"
R0.38	+/-0.030	0.375	✓		Rad gauge	
0.375	+/-0.010	0.373	✓		VERN	PHD-01
0.688	+/-0.010	0.685	✓		"	"
0.275	+/-0.010	0.273	✓		"	"
R0.13	+/-0.030	0.130	✓		Rad gauge	
0.25	+/-0.030	0.247	✓		VERN	PHD-01
1.06	+/-0.030	1.057	✓		"	"
0.125	+/-0.010	0.125	✓		"	"
0.86	+/-0.030	0.863	✓		"	"
Ø0.323	+0.005/-0.001	0.325	✓		"	"

Measured by:	PD / B.A
Date:	12/05/05

Audited by:	PR
Date:	12.5.5

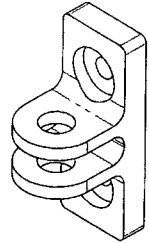
Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	
B	11.10.13	Dimension 0.25 removed	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82356 MLJ
12/03/29






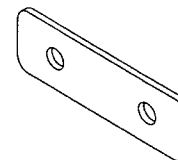
D4072-1 AIRFRAME HINGE

NOTES:

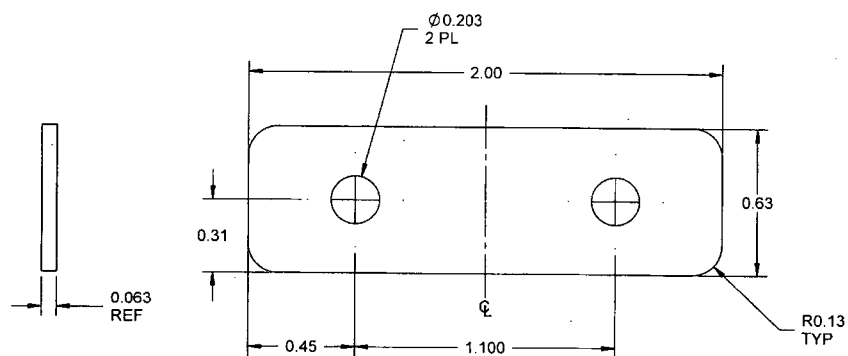
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T65
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2011-06-30
AM

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4072	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AIRFRAME HINGE	NTS
DATE	10.11.02	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



82356



D4072-3 AIRFRAME HINGE BACKING PLATE

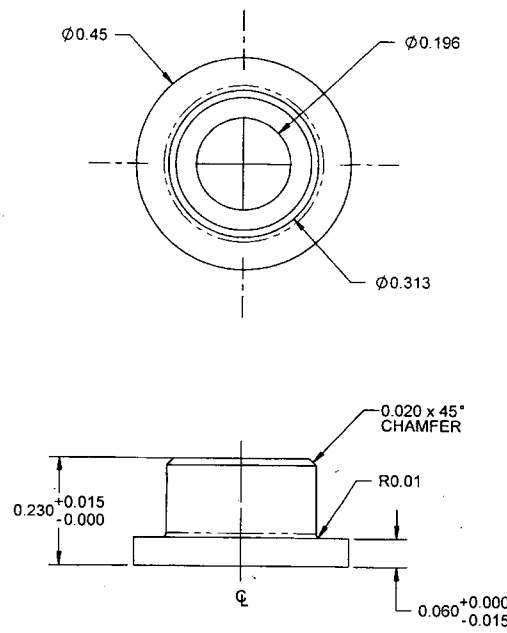
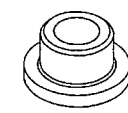
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

RELEASED
2011-06-30

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4072	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AIRFRAME HINGE	NTS
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82356



D4072-5 BUSHING

RELEASED
 2011-06-30

- NOTES:**
 1) MATERIAL: AISI 303 STAINLESS STEEL BAR
 REF DART SPEC. M303B
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: PER QSI 044 6.1
 7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4072	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AIRFRAME HINGE	NTS
DATE	10.11.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	